

Work Order ID 105616

Thursday, August 08, 2013 2:35:47 PM

105616

Page 1

Item ID: D4148-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eyebolt Stud
 Start Date: 8/8/2013 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 8/22/2013 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: *MLJ* Date: *13-08-08* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	D								
100		0.00							
100		0.00				30	0		DAS 08 9-09
Doosan	Memo								
Doosan Lathe	turn as per dwg and folio FA951								
	DWG REV: <u>D</u>								
	FOLIO REV: <u>AA</u>								
	DEBURR								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110		0.00				30	0		DAS 08 9-09
QC	Memo								
Quality Control									

D.A. 13/08/10

D.A. 13/08/10

Work Order ID 105616

105616

Page 2

Thursday, August 08, 2013 2:35:47 PM

Item ID: D4148-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Eyebolt Stud

Start Date: 8/8/2013 Start Qty: 40.00

40

Cust Item ID:

Required Date: 8/22/2013 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

20

3-8-12

30

4

120

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: ST145

0.00

150

Packaging

Memo

0.00

Packaging

30x

M. H. 13-08-12

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML5

13-08-21

MF

13-8-12

Picklist Print

Thursday, August 08, 2013 2:35:50 PM

Page 1

Work Order ID: 105616

105616

Parent Item: D4148-5

D4148-5

Parent Item Name: Eyebolt Stud

Start Date: 8/8/2013

Required Date: 8/22/2013

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP
REV:B 11.03.02 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R1.000

Purchased

No

100

f

53.9423

0.2

8.421053

M303R1 000

**

B.A

13/08/10

303 Round Bar 1.00

Location

Loc Qty

Loc Code

MAT028

53.94231579

120866

1.4

121070

6.63031579

121282

0.9

121728

3.034

122386

14.926

123294

5

→ 124711

22.052

→ 126151

0.666 ft

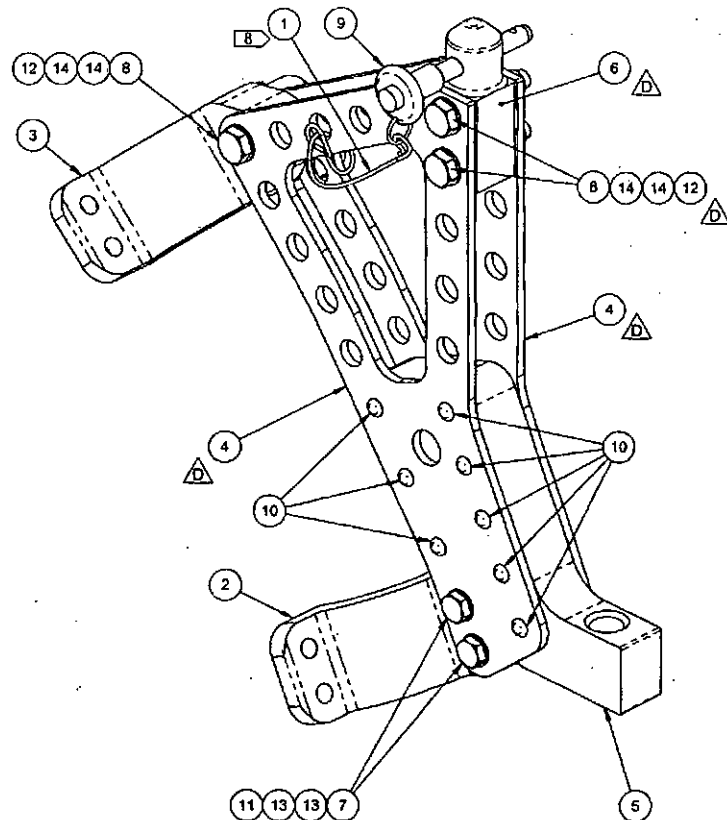
~~5.833 ft~~

8.500 ft

mat not pulled

φ 1.000 (304)
55
this batch only

8 7 6 5 4 3 2 1



D4148-041 FWD X-TUBE LUG ASSY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

RELEASED
2011-02-24

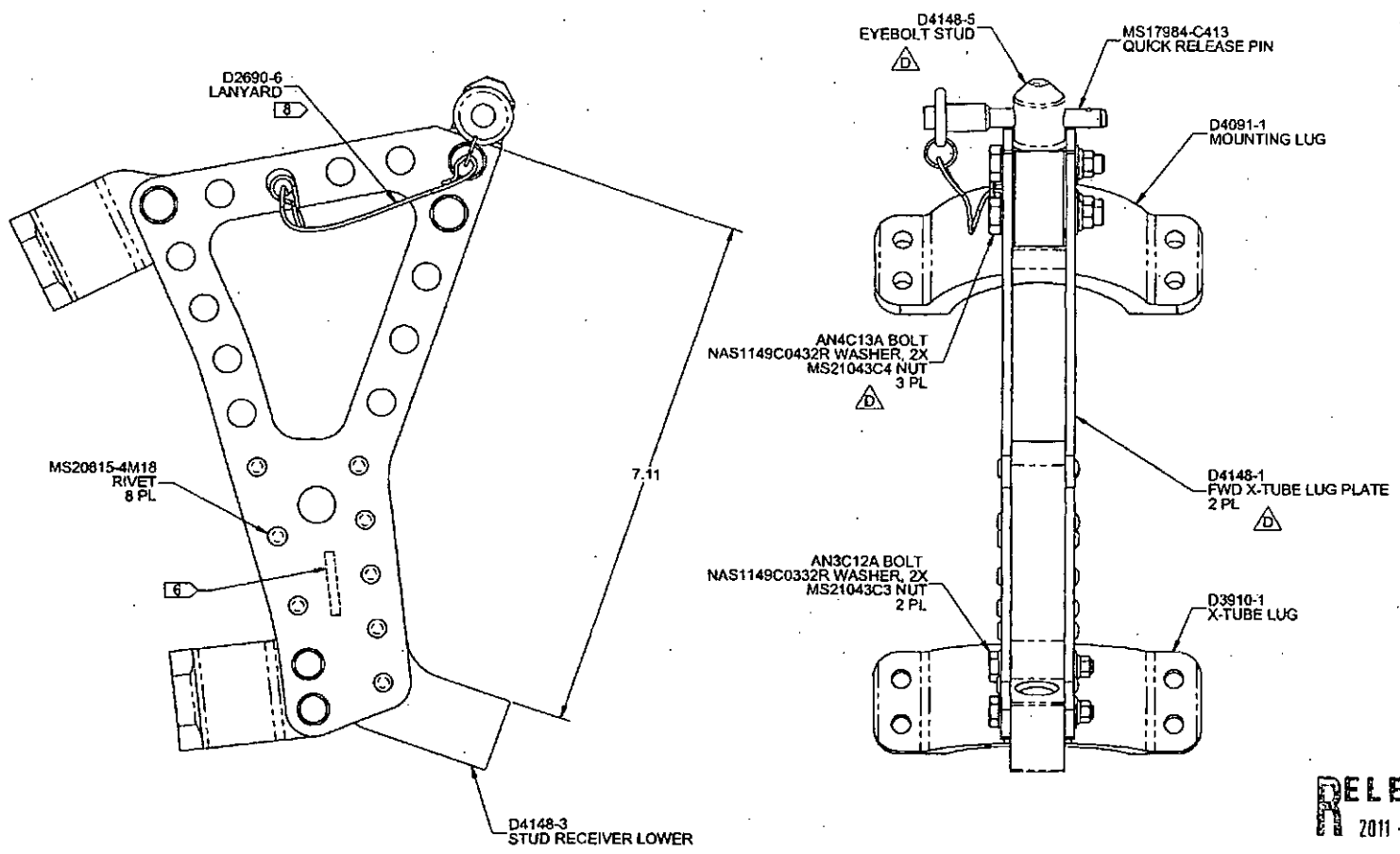
105616 MLJ
17-08-08

D	HOLE DIA CHANGED TO 0.252" (D3-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1A3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-5B1 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20515-4M20 (ZN D3-1 & B7-2); Ø0.181 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.181 WAS 0.128 (ZN C8-5). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED AS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSES OR IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
 - 7) WEIGHT: 3.67 lbs
 - 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

8 7 6 5 4 3 2 1

105616

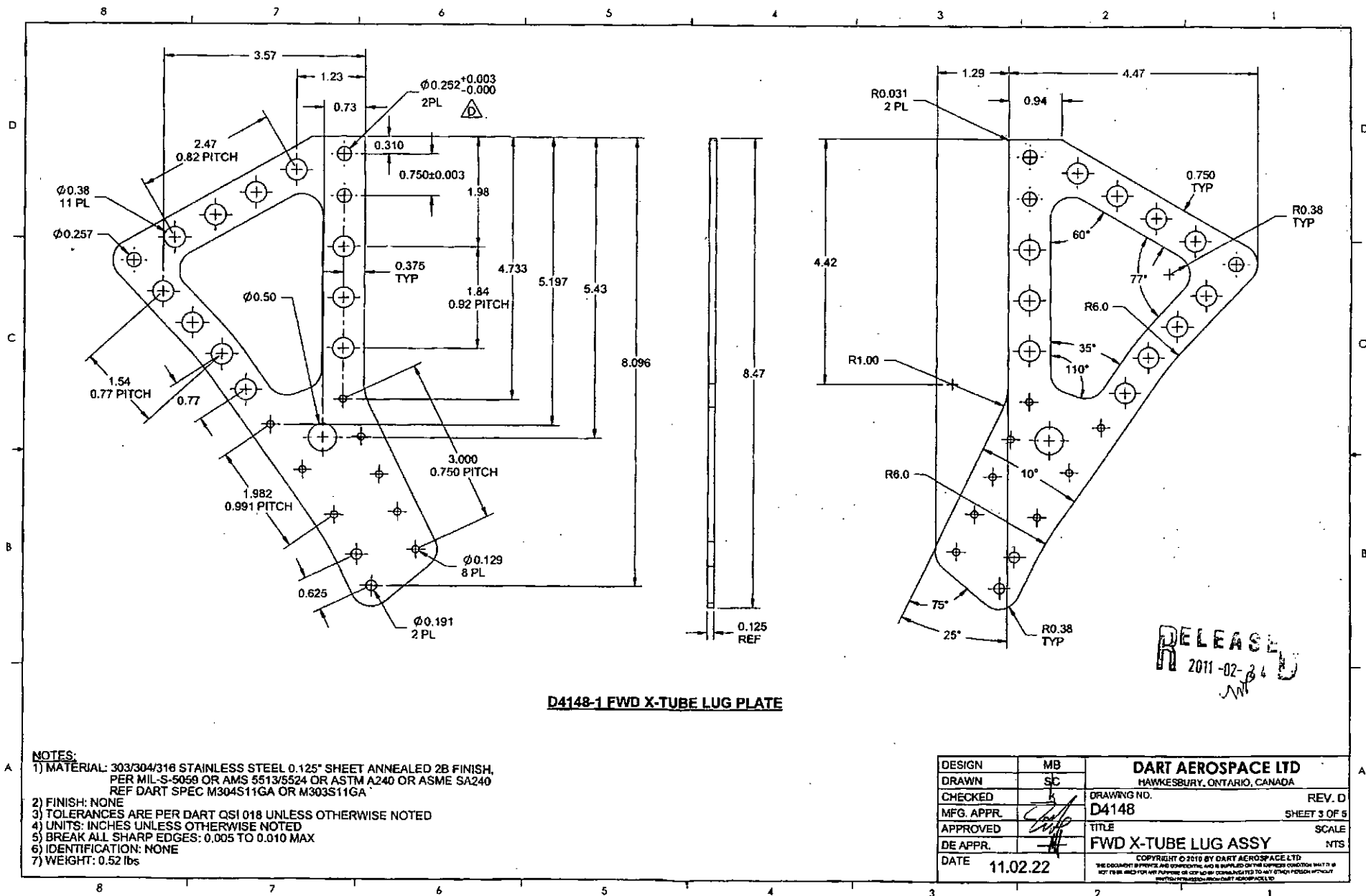


D4148-041 FWD X-TUBE LUG ASSY

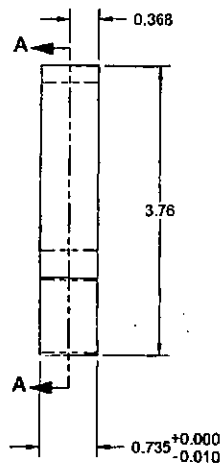
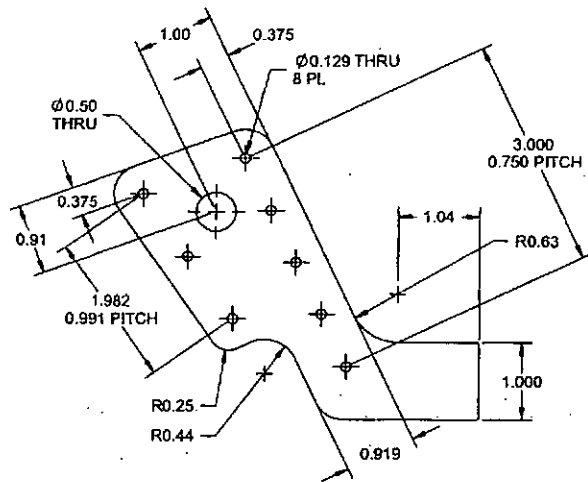
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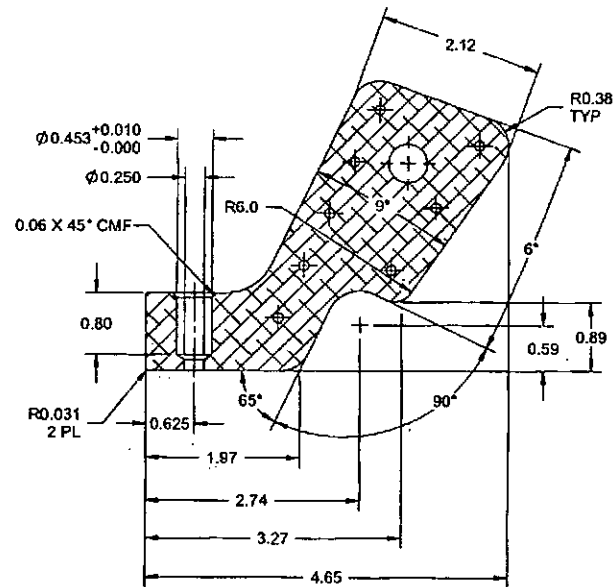
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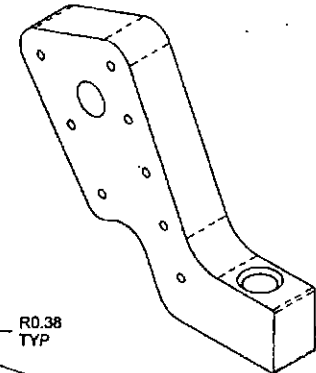
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D4148-3 STUD RECEIVER LOWER



SECTION A-A



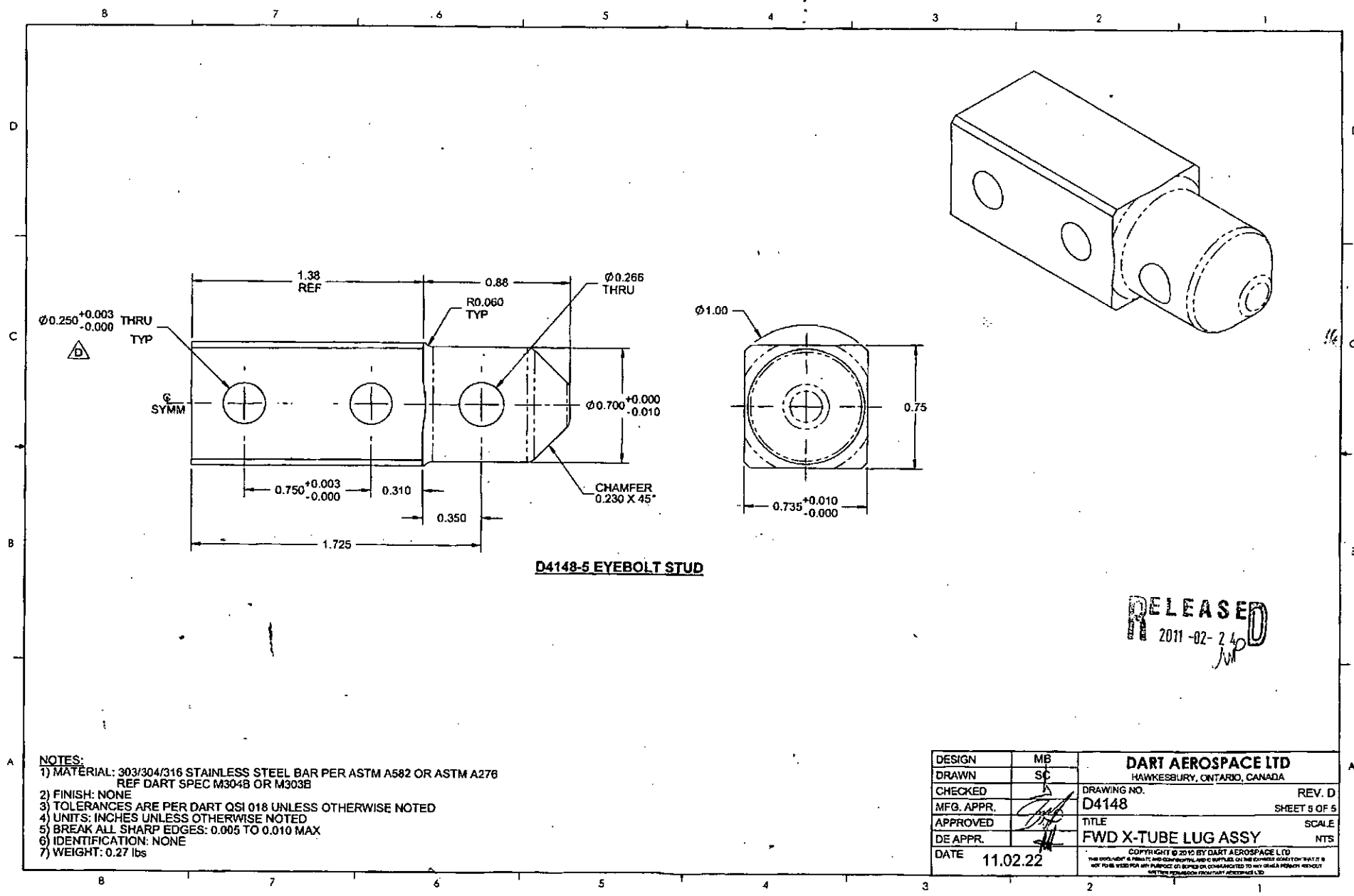
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2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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105216



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2011-02-24

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD	
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